

Date: Monday, 28/04/2008 3:33:25 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: INSTALL D350-636-043
Job Number	: 38847		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D350636013
This Issue	: 28/04/2008 S.O. No. :	Drawing Number	: D350-636-013
Prsht Rev.	: NC	Project Number	:
First Issue	: // Type : SKIDTUBES	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: <u>W</u>	Due Date	: 29/04/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPP

CH002-003 W

08/4/29 JLD

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D350-636-013 B 32529 W 08.04.28

3.0	D350636013	Skidtube LH
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(1X)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Skidtube LH

B 3 2 5 2 9 M-L 08/04/29

4.0	D350636043	Wearshoe
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(1X)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Wearshoe

B 3 8 8 4 5 M-L 08/04/29
~~11/11~~ ~~M-L 08/04/29~~

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(1X)

Comment: HAND FINISHING RESOURCE #1
 INSTALL D350-636-043 B

B 3 2 5 2 9 M-L 08/04/29

Date: Monday, 28/04/2008 3:33:25 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INSTALL D350-636-043

Job Number: 38847

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/29 (K)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(H)

Comment: PACKAGING RESOURCE #1

RE-PACKAGE PER PPP

USING NEW B/N - CHG002

NEW LABELS REQ'D

003 u

Rev F

8/1/29

SEP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/29

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/04/29



B32529



RELEASED
07.08.02

DESIGN <i>PH</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 1 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

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E

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

info
38007

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DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 2 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

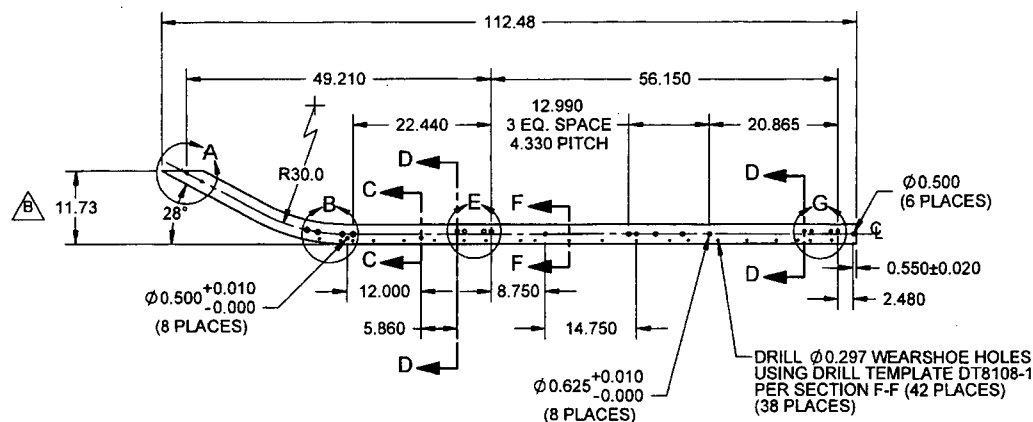
GENERAL NOTES:

RELEASED
07-08-02 *[Signature]*

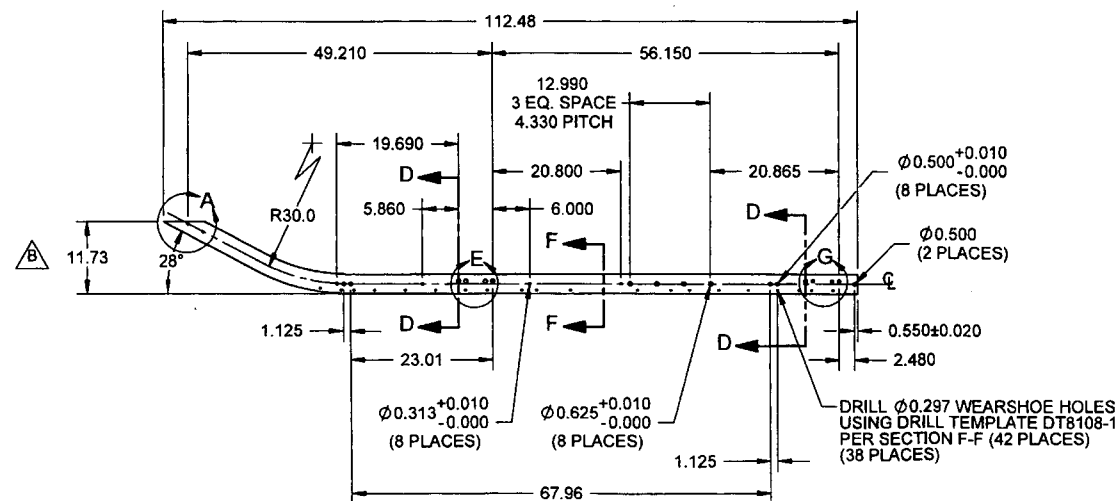
1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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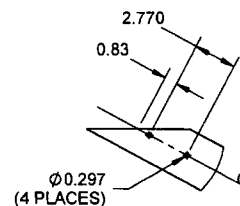
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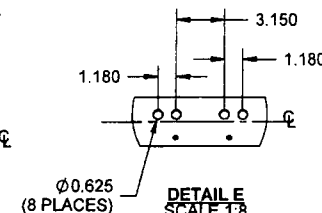
D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)



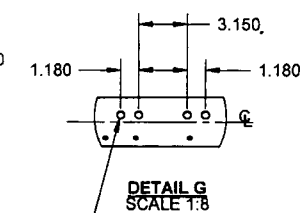
D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)



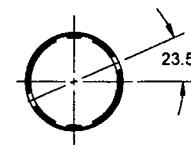
DETAIL A
SCALE 1:8



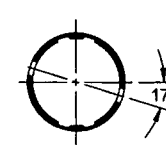
DETAIL E
SCALE 1:8



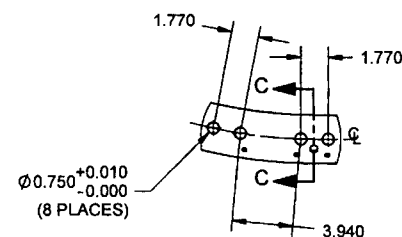
DETAIL G
SCALE 1:8



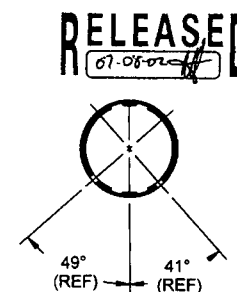
SECTION C-C
SCALE 1:4



SECTION D-D
SCALE 1:4




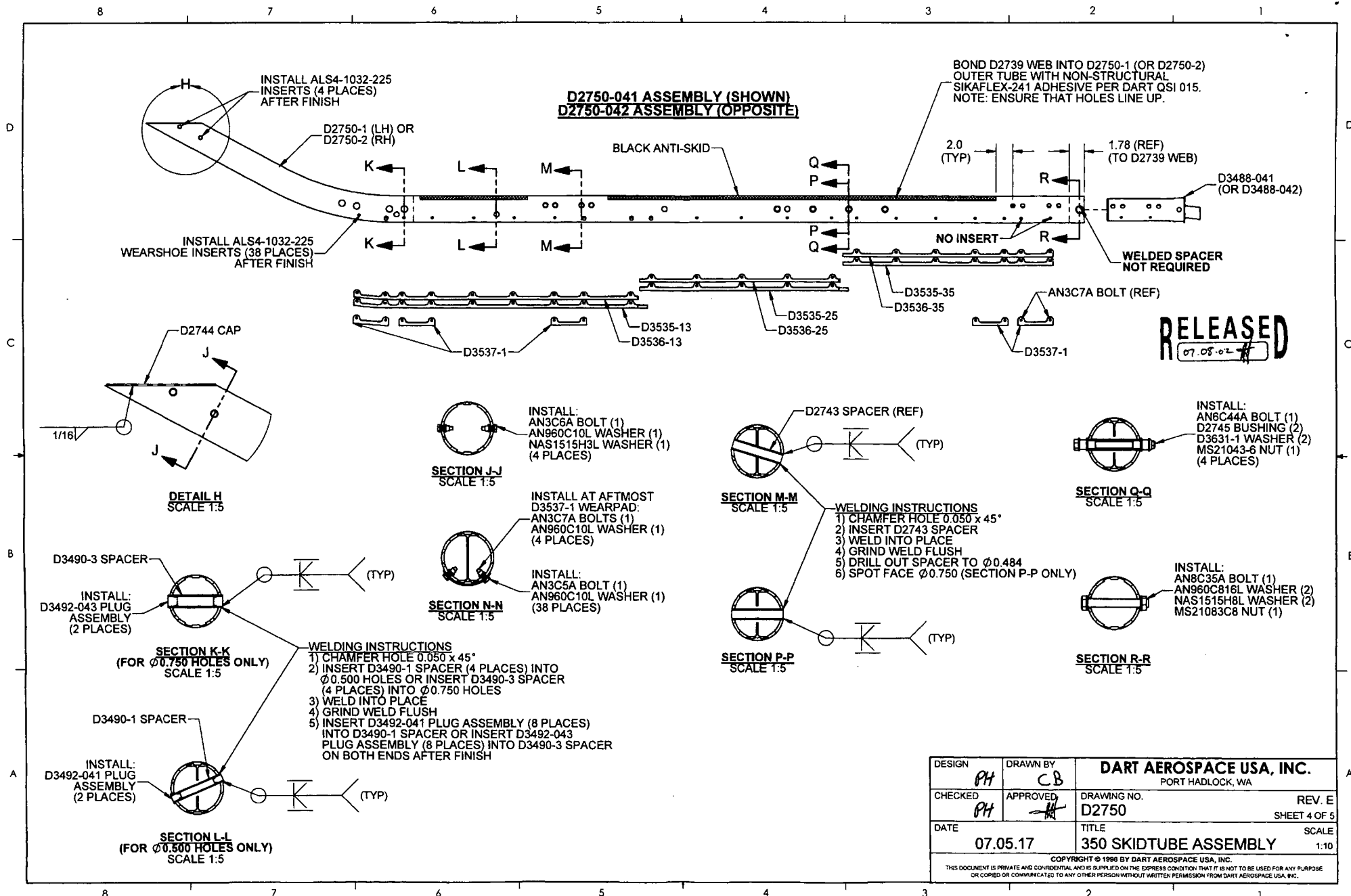
DETAIL B
SCALE 1:8
(ALL DIMENSIONS ARE
STRAIGHT LINE DIMENSIONS)

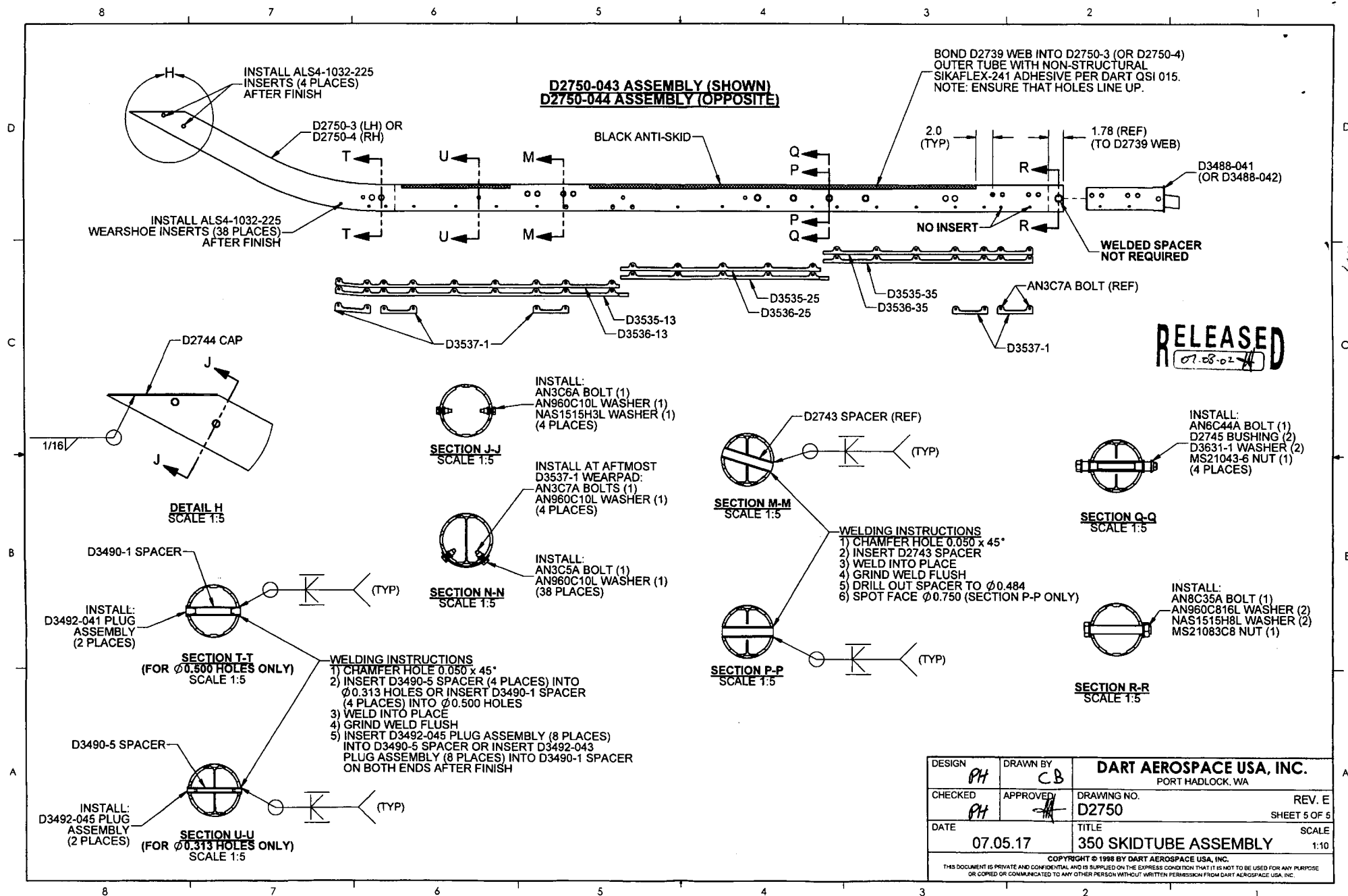


SECTION F-F
SCALE 1:4

RELEASED
07-05-17

DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED 	DRAWING NO. D2750	REV. E SHEET 3 OF 5
DATE 07.05.17	TITLE 350 SKIDTUBE ASSEMBLY		SCALE 1:20
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Date: Monday, 28/04/2008 3:36:37 PM
 User: Linda Lacey

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : INSTALL D350-636-043
Job Number : 38847	
Estimate Number : 10804	
P.O. Number :	Part Number : D350636013
This Issue : 28/04/2008 S.O. No. :	Drawing Number : D350-636-013
Prsht Rev. : NC	Project Number :
First Issue : 28/04/2008 Type : SKIDTUBES	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 29/04/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC

DOCUMENT CONTROL



JPD 08.4.29



Comment: Photocopy bluefile & type labels per PPP

CHG002-003

2.0 PACKAGING 1

PACKAGING RESOURCE #1



(N)

Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D350-636-013 B 32529

8/4/29

Sc

Job Completion



DART Aerospace Ltd

CUSTOMER RETURN

REFERENCE ONLY

#R08-052

Initiator: Jean Kerr
 Company: GCTPA
CGC1001
 Phone No.: 262-798-580

Date: MAY 14/08
 Invoice # 6445
 Order Entry # 5969

Reason for return: NK08-043 - wear plates have interference with the Eurocopter Saddle
 Attach Copy of DHS Return Authorization # 415

Receiving: 8/6/5 Date Received: 8/6/5 Freight Company: MINI MAX Prepaid ☐ Collect ☐

#	Part #	Batch #	Description	Distribute to QC	
1	D350-636-013	38847	Skid tube LH	Advise QA	Date:
1	D350-636-014	38853	Skid tube RH	<u>DATE</u>	<u>8/6/6</u>

Condition of packaging: GOOD Photograph required: yes ☐ no ☒

Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

QC: Quarantine: Location: Condition of Part: good

Inspect: Initial:

#	Part #	Batch #	QC Comments	QC Approval		Scrap
1	D350-636-014	B38853	re-work & update tubes as per DSI 9413 Rev A, per w/o's.	Initial	W/O #	
1	D350-636-013	B38847		<u> </u>	<u>39742</u>	
					<u>39751</u>	

QA Coordinator: Advise GM as to findings: Initial: Date:

Comments:

Issue credit: yes ☐ no ☐
 GM Approval: Date:
 Invoice Amount:
 Less Replacement:
 Restock Fee:
 Freight:
 Net Credit:
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: Date:

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit